

Work Order ID 61715

Tuesday, August 31, 2010 1:55:06 PM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Item Name: Latch Bracket

Stop



Start Date: 8/31/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

5052 .040

10-9-20

(24)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/09/20

counters
(x24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Deburr <input type="checkbox"/> Form on CNC Brake as per Dwg D2583	0.00 0.00	SB 10/09/22			(24)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	SID 10/22/22			counted (24)			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BK 10-9-23			(24)			

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Page 4

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Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL 10/09/28

10/09/28

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Picklist Print

Tuesday, August 31, 2010 1:55:10 PM

Page 1

Work Order ID: 61715

Parent Item: D2583

Parent Item Name: Latch Bracket



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat- in house process□DM□
IPP: D□06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040 		Purchased	No			100	sf	47.2234	0.1169	2.461053	2.9	1310-9-20	
5052-H32 .040 Sheet													

Location

Loc Qty

Loc Code

MAT

35.8

114488

35.8

MAT23

11.4234

101875

1.5

109058

8.5234

113123

1.4

109058

(24)

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Dart Aerospace Ltd

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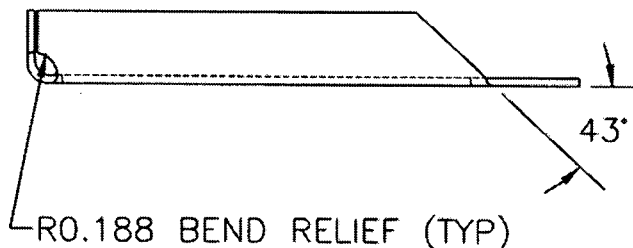
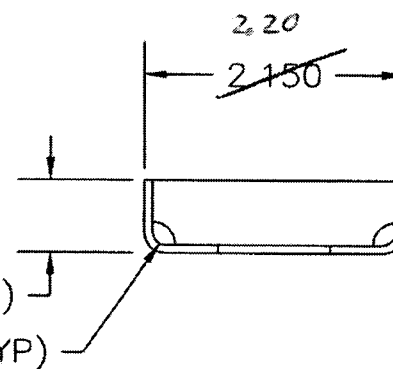
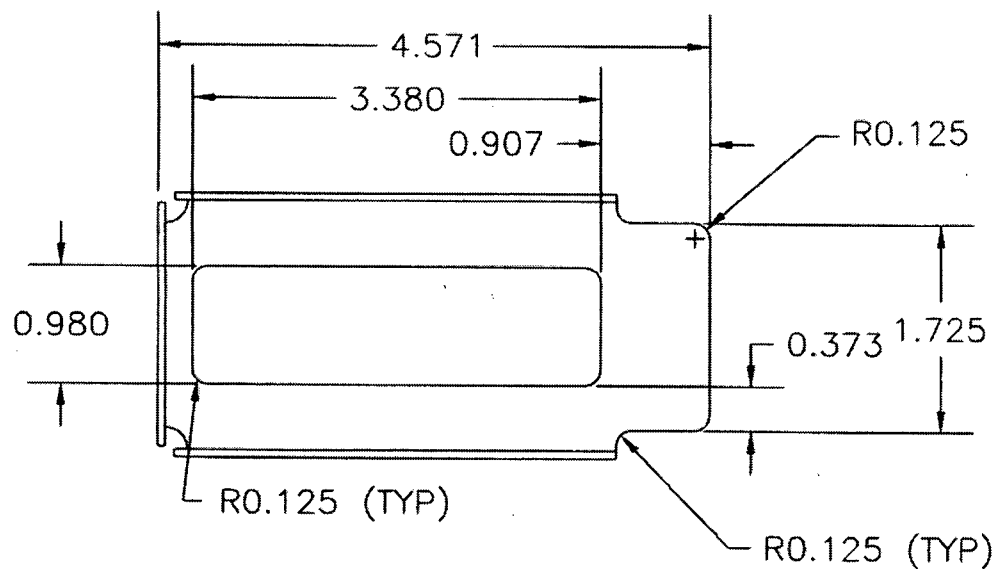
DART



RELEASED
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61715
3810-8-3

KE 99.02.26



DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B SHEET 1 OF 1
A	96.07.10	NEW ISSUE		SCALE 2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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